

Work Order ID 75298

October-20-11 9:58:39 AM

75298

Page 1

Item ID: D2989-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100
100
 Large Fab
 Large Fab
 Large Fab
 Memo
 1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
 ****cut cutouts with zip cut as per dwg D3832****
 3- remove from jig and weld lable plate as per dwg D2989
 A/R ER316 S.S. Rod Batch: 121602
 *** PLEASE NOTE****
 IF MAKING -043A :
 ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
 DSI9473

CC / Rpl 12.7.17

110
110
 QC
 Quality Control
 QC9- Insp visual per QSI004- Fusion Welds
 Memo

1 φ 12.7.17



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75298***75298***

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Item ID: D2989-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid Assembly

Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

DAS
16
17/11/17

1 7/15 12-7-17

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: 1:30

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:00

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

131

Wing Walk as per dwg QSI005 4.4 Batch 121505 0:00

131

HandFinish

Hand Finishing

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: 120817

M121841

IX *MA*
12/07/17

1 *p* *B12-7-18*

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Picklist Print

October-20-11 9:58:45 AM

Page 1

Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	16.0000	2	2			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		16							
				71372		4							
				72297		12							
D2506 *D2506* Label Plate		Manufactured	No			100	Each	12.0000	1	1			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		12							
				71087		2							
				74142		10							
D2512-7 *D2512-7* Rib		Manufactured	No			100	Each	5.0000	1	1			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
				53444		0							
				71220		4							
				WA006		1							
				67445		1							

Pl 12.7.17
 B83907 → ②

Pl 12.7.17
 B82705 → ①

Pl 12.7.17
 B75
 B77522 → ①

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100 Each 31.0000 2 2

D2581

Mounting Bracket

**

Location

Loc Qty

Loc Code

WA

31

69739

2

70766

2

73079

6

73762

21

386058 → 2

CP

D2989-13 Manufactured No

100 Each 8.0000 2 2

D2989-13

Rib

**

Location

Loc Qty

Loc Code

WA

8

71556

2

72410

6

~~377519~~ → 2
384604 → 2

D2989-19 Manufactured No

100 Each 8.0000 2 2

D2989-19

Rib

**

Location

Loc Qty

Loc Code

WA

8

71477

2

72411

6

377519 → 2

D3832-3 Manufactured No

100 Each 3.0000 1 1

D3832-3

Mesh (Lid)

**

Location

Loc Qty

Loc Code

WA

3

71301

3

377519 → 1
86576

October-20-11 9:58:45 AM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75298

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Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100 Each 17.0000 2 2

D3833-3 ✓

Mesh (Lid End)

**

Location

Loc Qty

Loc Code

WA

17

67460

17

D3836-041 Manufactured No

100 Each 3.0000 1 1

D3836-041

Rib Assembly (Basket Lid, LH)

**

Location

Loc Qty

Loc Code

WA

2

72412

2

WA005

1

71746

1

D3836-042 Manufactured No

100 Each 3.0000 1 1

D3836-042

Rib Assembly (Basket Lid, RH)

**

Location

Loc Qty

Loc Code

WA

2

72413

2

WA005

1

71745

1

D3852-041 Manufactured No

100 Each 3.0000 1 1

D3852-041

Rib Assembly

**

Location

Loc Qty

Loc Code

WA

3

70722

3

CPL 12.7.17
B67460 → ①
B87051 → ①

CPL 12.7.11
B77515 → ①

CPL 12.7.11
B77514 → ①

CPL 12.7.11
B86154 → ①

October-20-11 9:58:45 AM

Shop Packet Print

Page 3

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October-20-11 9:58:45 AM

Page 4

Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

4.0000

1

1

D3852-042

Rib Assembly

**

Location

Loc Qty

Loc Code

WA

4

66089

1

70723

3

PL 12.07.11
B86043 → ①

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75298 M.L.O
11/10/20

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D3227-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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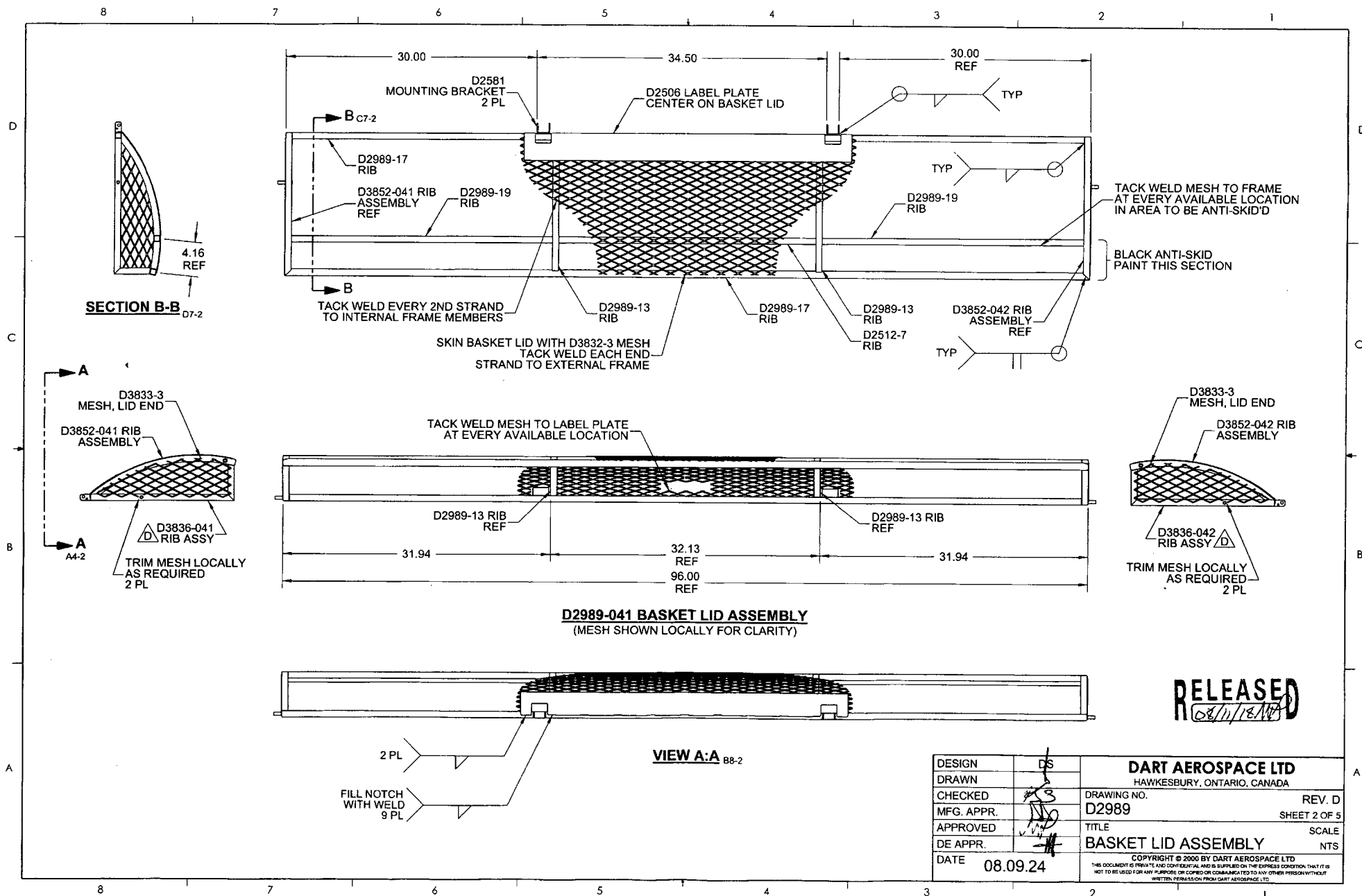
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
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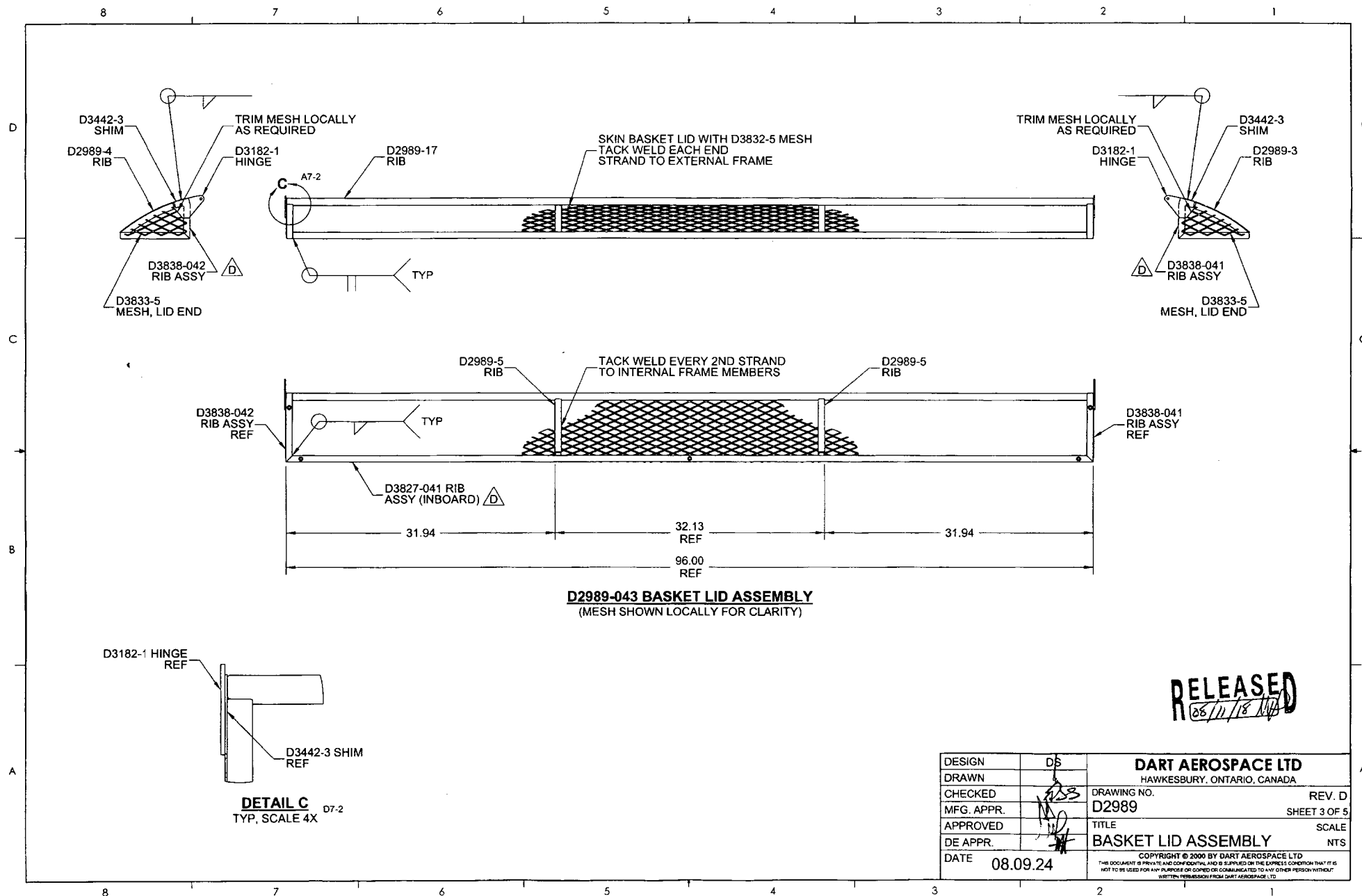
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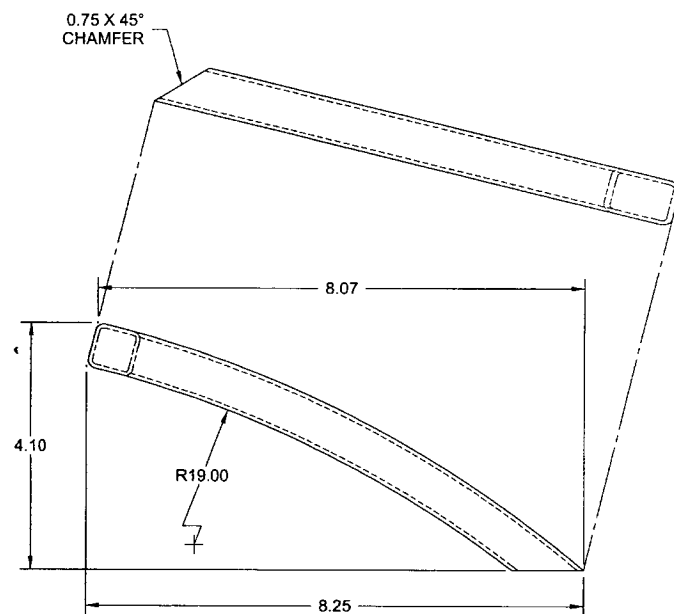
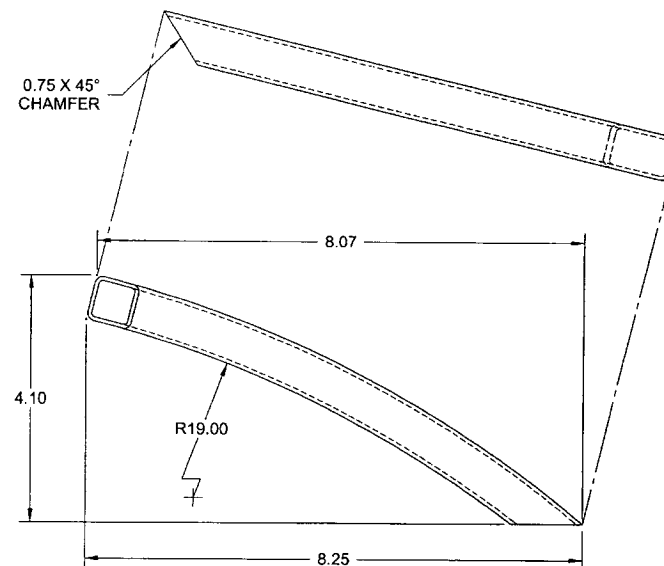
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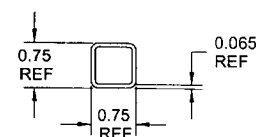
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**D2989-3 RIB****D2989-4 RIB****NOTES:**

- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

**TYPICAL SECTION
VIEW****RELEASED**
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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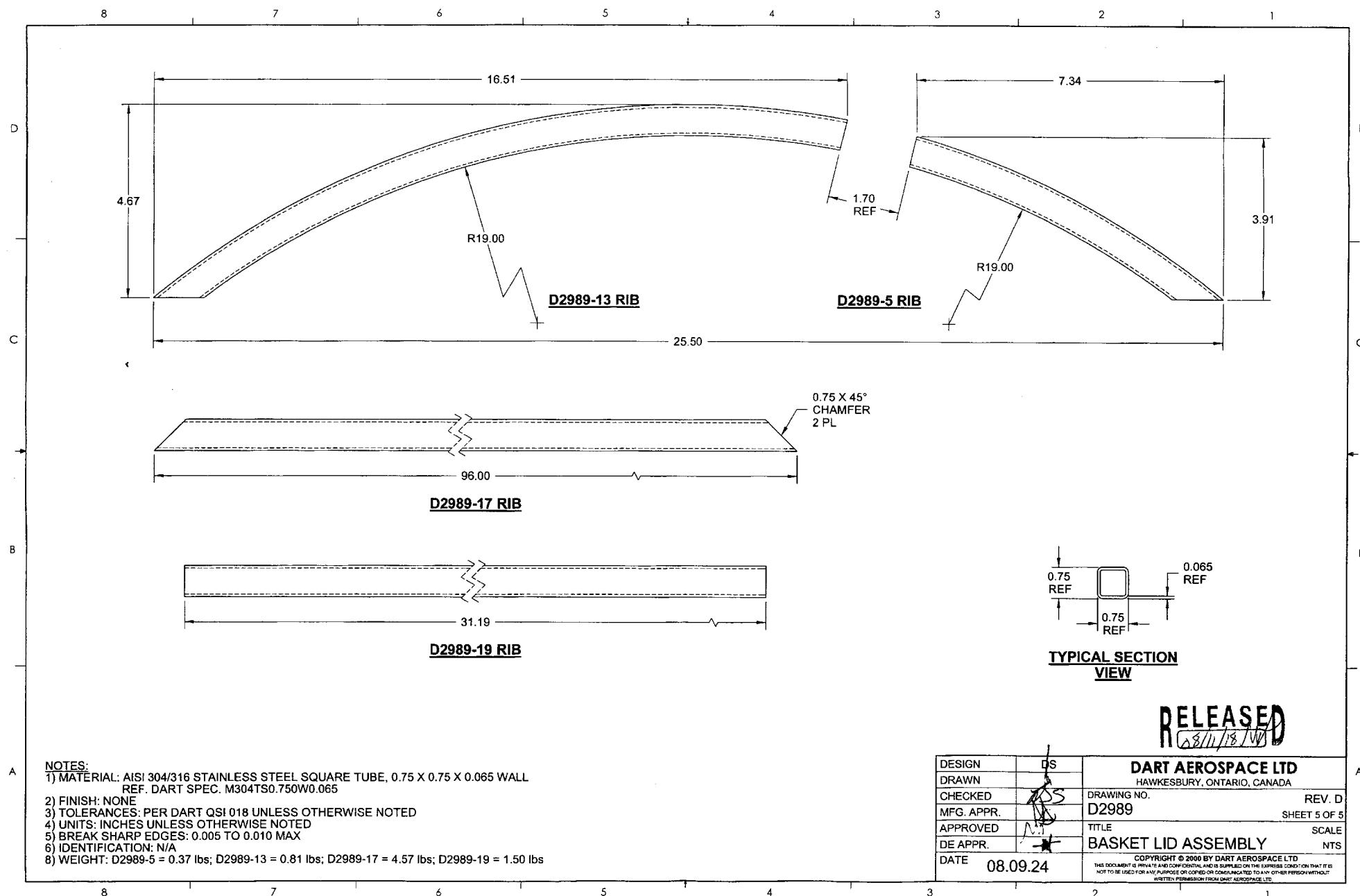
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08/11/18/VW

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CHECKED		DRAWING NO.	REV. D
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DE APPR.		BASKET LID ASSEMBLY	NTS
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